

Tuesday, June 14, 2011 7:41:46 AM



Accept

**Setup Start**

Stop




Start Date: 6/13/2011 **Start Qty:** 10.00
Required Date: 6/17/2011 **Req'd Qty:** 10.00



Cust Item ID:
Customer:

Reference:



Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4353	B								
120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D4355-3 File								
130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per FolioFB051 and Dwg FOLIO REV: <u>AB</u> DWG REV: <u>B</u> 3-Deburr								

IB 11-6-14

Ph ~~_____~~

Just 11.06.21 (3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	120	10 Blanks SCRAP. USB Not updated for New Blank Size						

Part No: D4353-3 PAR #: N/A Fault Category: Production Engineer ^{WS} NCR: Yes No DQA: H Date: 11.06.23
 Resolution: SCRAP Disposition: Scrap QA: N/C Closed: OK Date: 11/06/24

NCR: <u>70327</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>40.81</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/2/21</u>	<u>#100</u>	<u>24 x10 Blanks</u> <u>Scrap</u> <u>USB not updated for</u> <u>new Blank Size</u> <u>R.C. LQA</u>	<u>OSI42</u>	<u>Update USB</u> <u>& write Blank</u> <u>Size in comment</u> <u>+ Rep/Re 24 x3</u>	<u>11/26/21</u>	<u>S</u> <u>11/06/22</u>	<u>OSI42</u>	<u>S</u> <u>11/06/22</u>

NOTE: Date & initial all entries

Work Order ID 70727

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Page 3

Item ID: D4353-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bearpaw Insert

Start Date: 6/13/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

11/6/22 
MF
11-06-22

Picklist Print

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Page 1

Work Order ID: 70727



Parent Item: D4353-3



Parent Item Name: Bearpaw Insert

Start Date: 6/13/2011

Required Date: 6/17/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 11-04-13 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

sf

300.6000

2.105263



UHMW 1" Black

11-6-14

Location

Loc Qty

Loc Code

MAT018

300.6

117321

76.6

117738

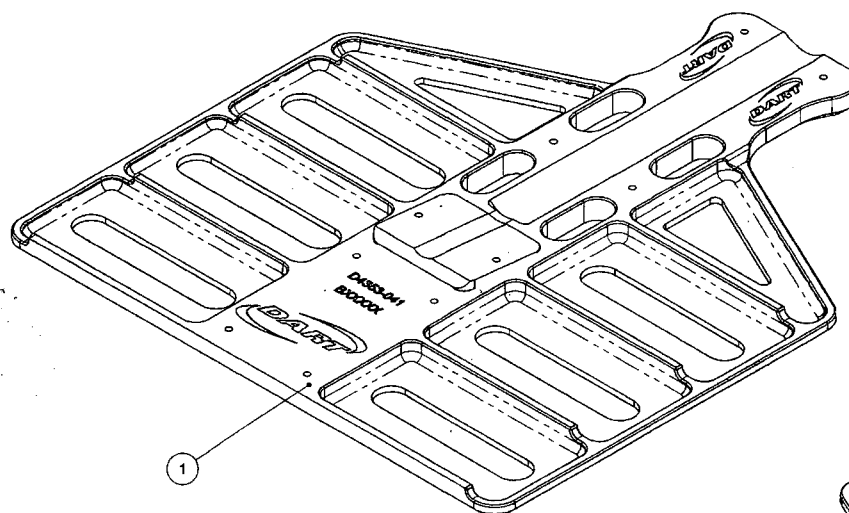
59

117819

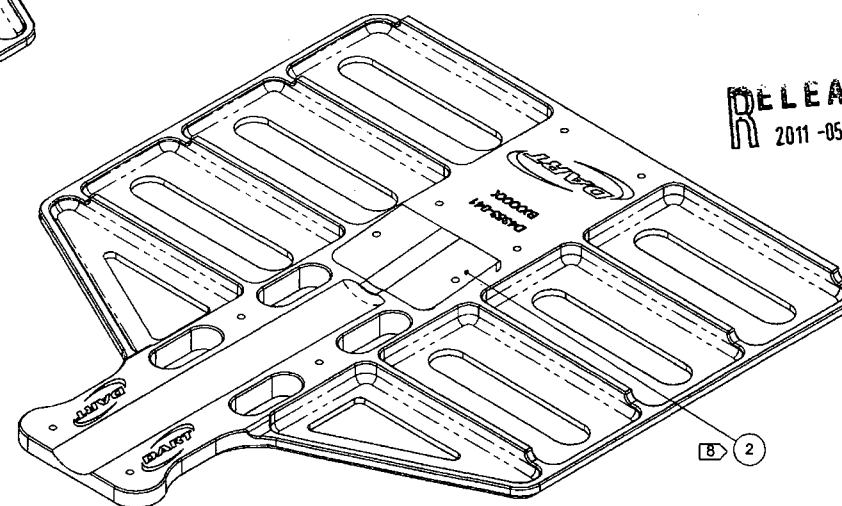
165

117819

ITEM	QTY	P/N	DESCRIPTION
	X	D4353-041	429 BEARPAW ASSEMBLY
1	1	D4353-1	429 BEARPAW
2	1	D4353-3	429 BEARPAW INSERT



D4353-041 429 BEARPAW ASSEMBLY



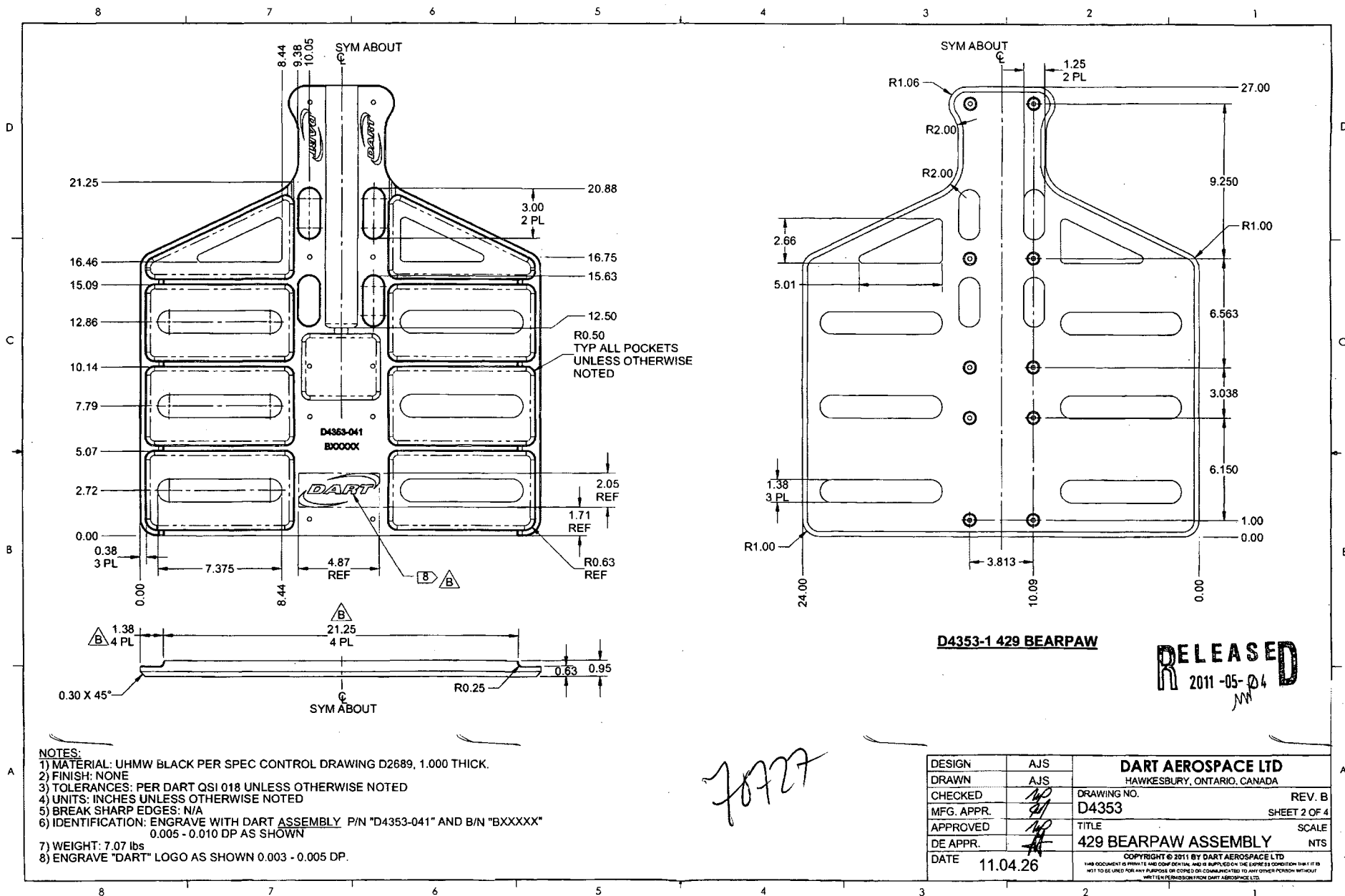
RELEASED
2011-05-24

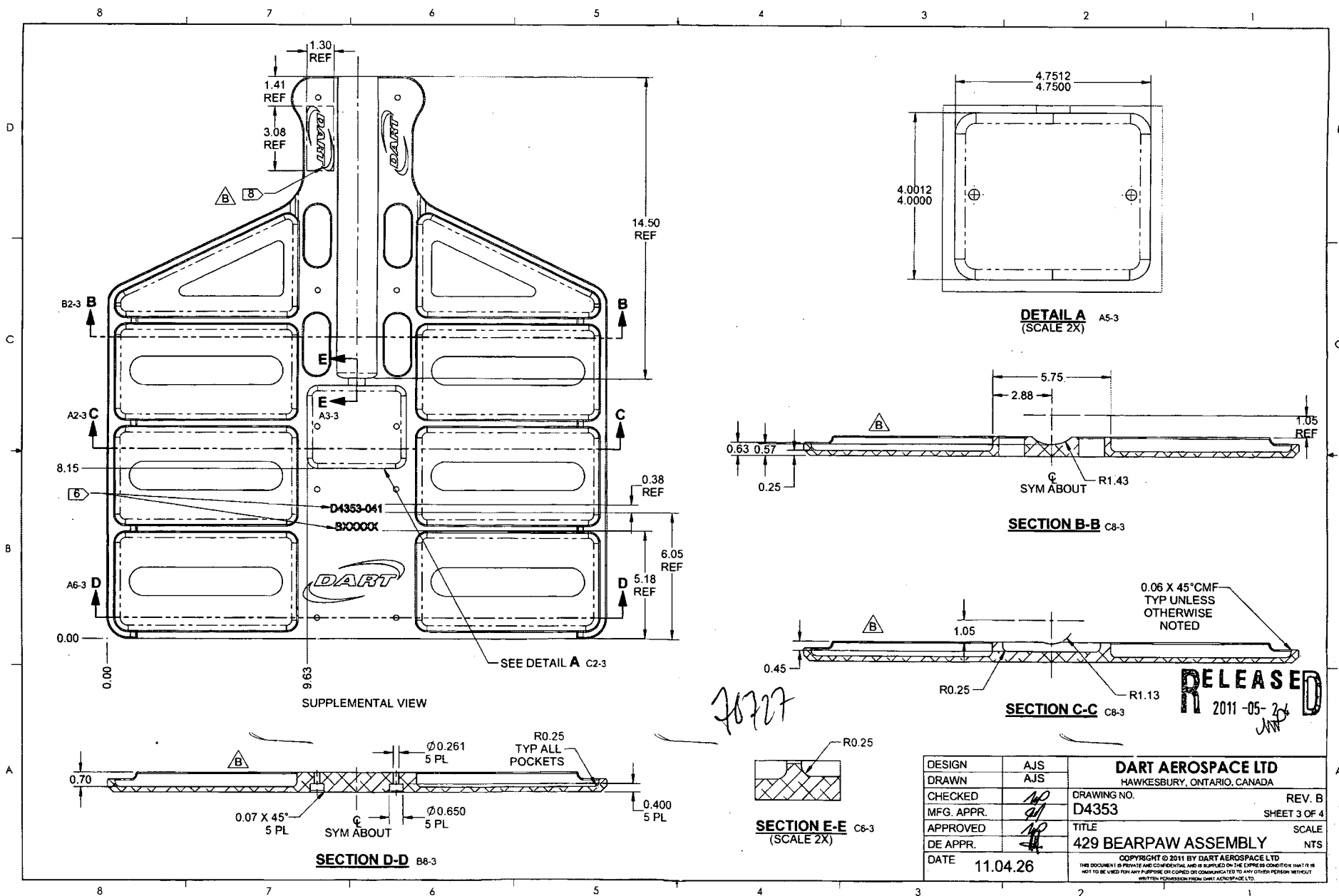
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 7.45 lbs
 - 8) PRESS FIT

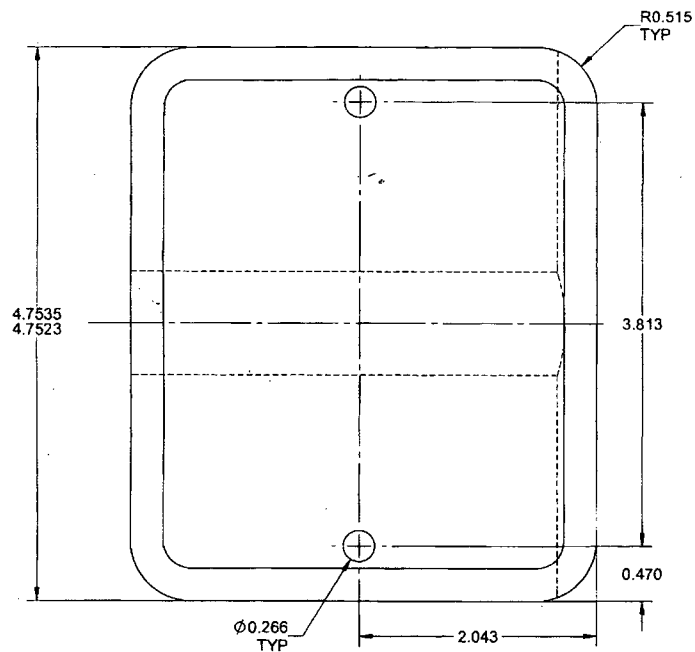
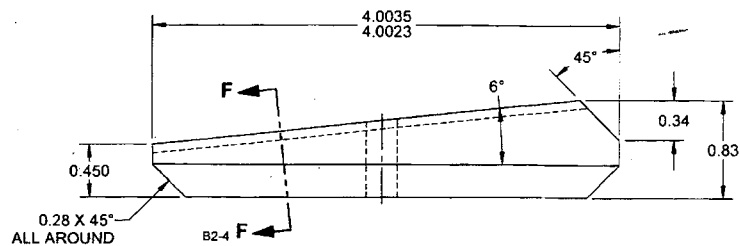


B	SHT 1 WEIGHT CORRECTED WAS 8.24 lbs. SHTS 1-3 DART LOGOS UPDATED. SHT 2, ZONE B8, AFT POCKET REDUCED, RIB INCREASED IN HEIGHT. SHT 3 SECTS. B, C & D RIB INCREASED IN HEIGHT.		AJS	11.04.26
A	NEW ISSUE		AJS	11.03.24
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		DRAWING NO.	REV. B
CHECKED	[Signature]		D4353	SHEET 1 OF 4
MFG. APPR.	[Signature]		TITLE	SCALE
APPROVED	[Signature]		429 BEARPAW ASSEMBLY	NTS
DE APPR.	[Signature]		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	11.04.26			

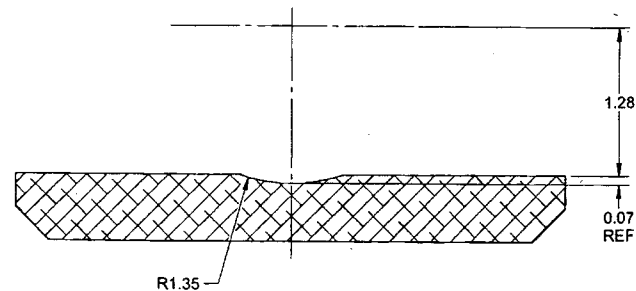
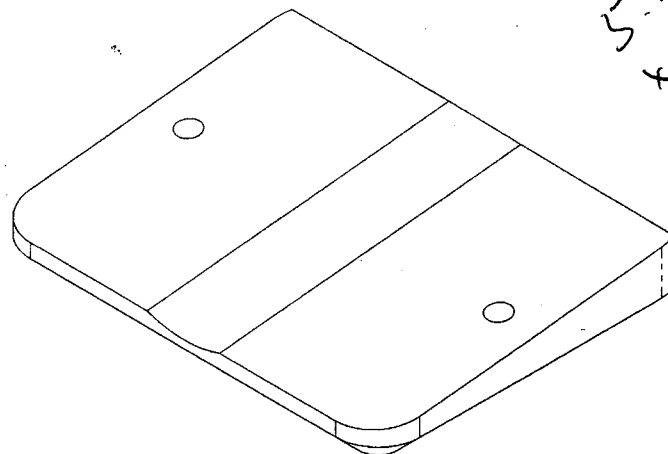
to 20707







D4353-3 429 BEARPAW INSERT



SECTION F-F C7-4

RELEASED
2011-05-26

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.38 lbs

70827

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO.	REV. B
MFG. APPR.	MD	D4353	SHEET 4 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	429 BEARPAW ASSEMBLY	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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